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SUPERCEDED BY

05.06.13

DART



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D212-664-241	REV. A SHEET 1 OF 3
DATE 00.12.12		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE NTS
A	00.12.12	NEW ISSUE	

Qty	Part Number	Description
X	D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
1	D6006-129	CROSSTUBE
2	D2940-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP

GENERAL NOTES:

- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = ~~123.76 ± 0.020~~ 124.36 ± 0.010
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- PART IS SYMMETRIC ABOUT CENTERLINE. 5 # 01.01.29
- RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH. CP 01.01.30
- BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/291 SEALANT.
- TORQUE CLAMPS 80 TO 100 IN-LB.

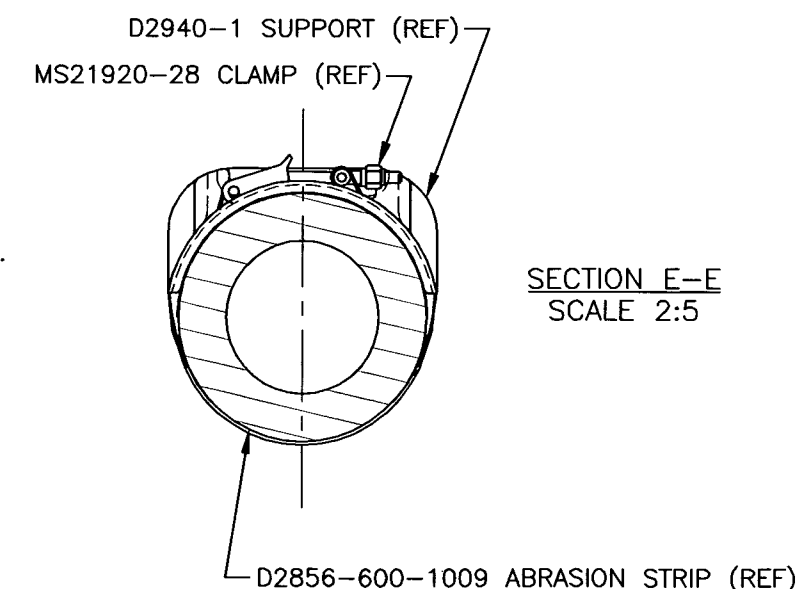
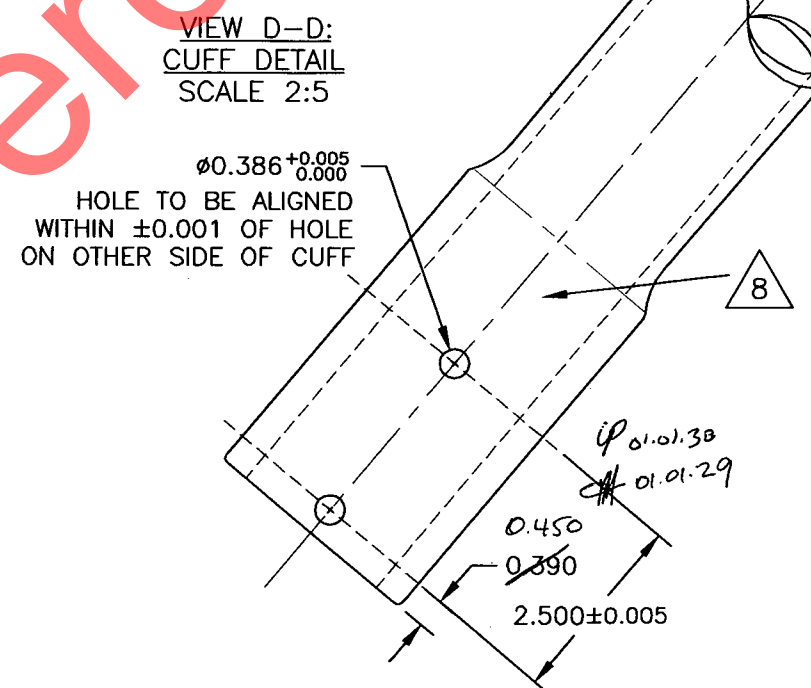
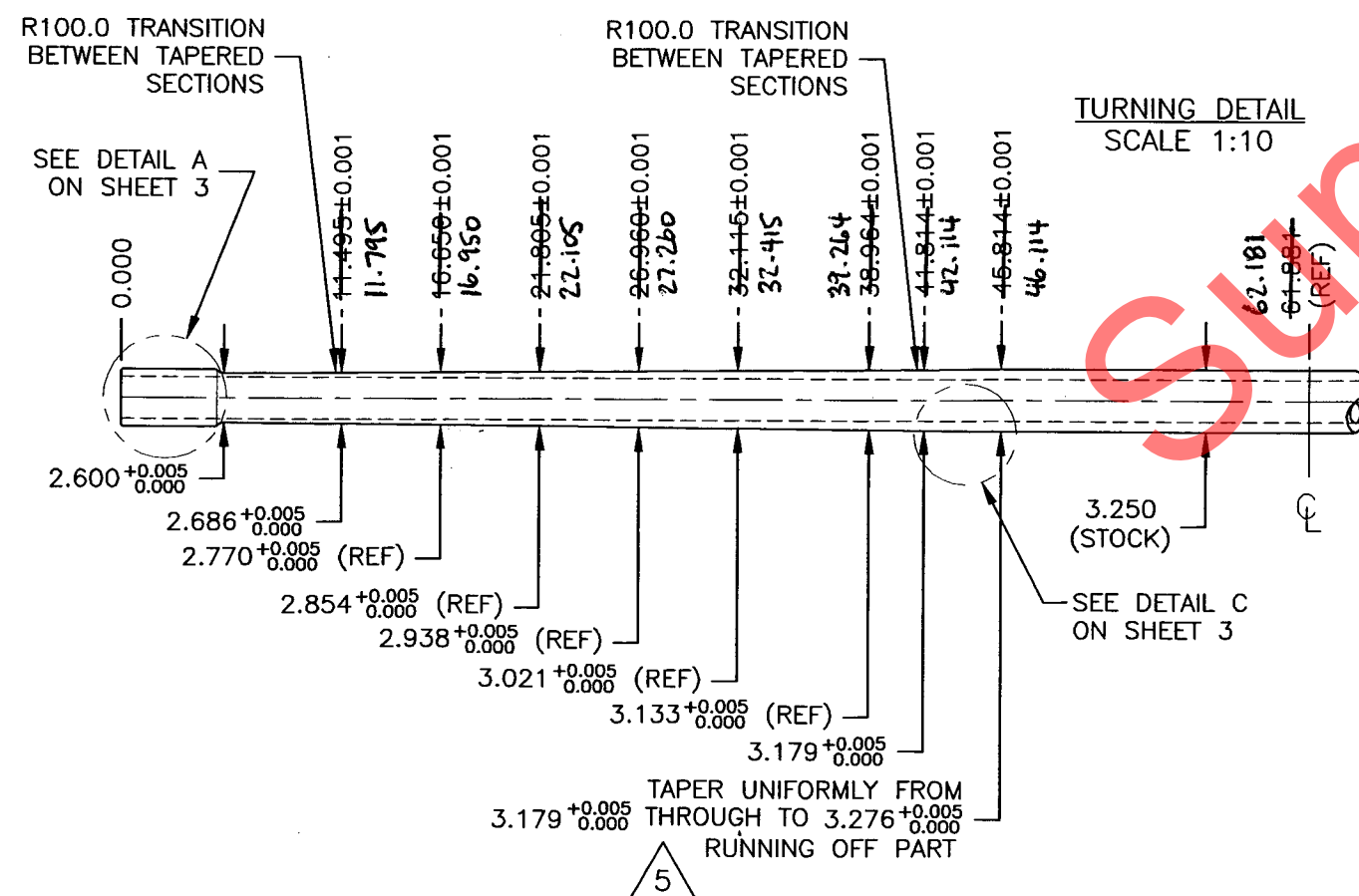
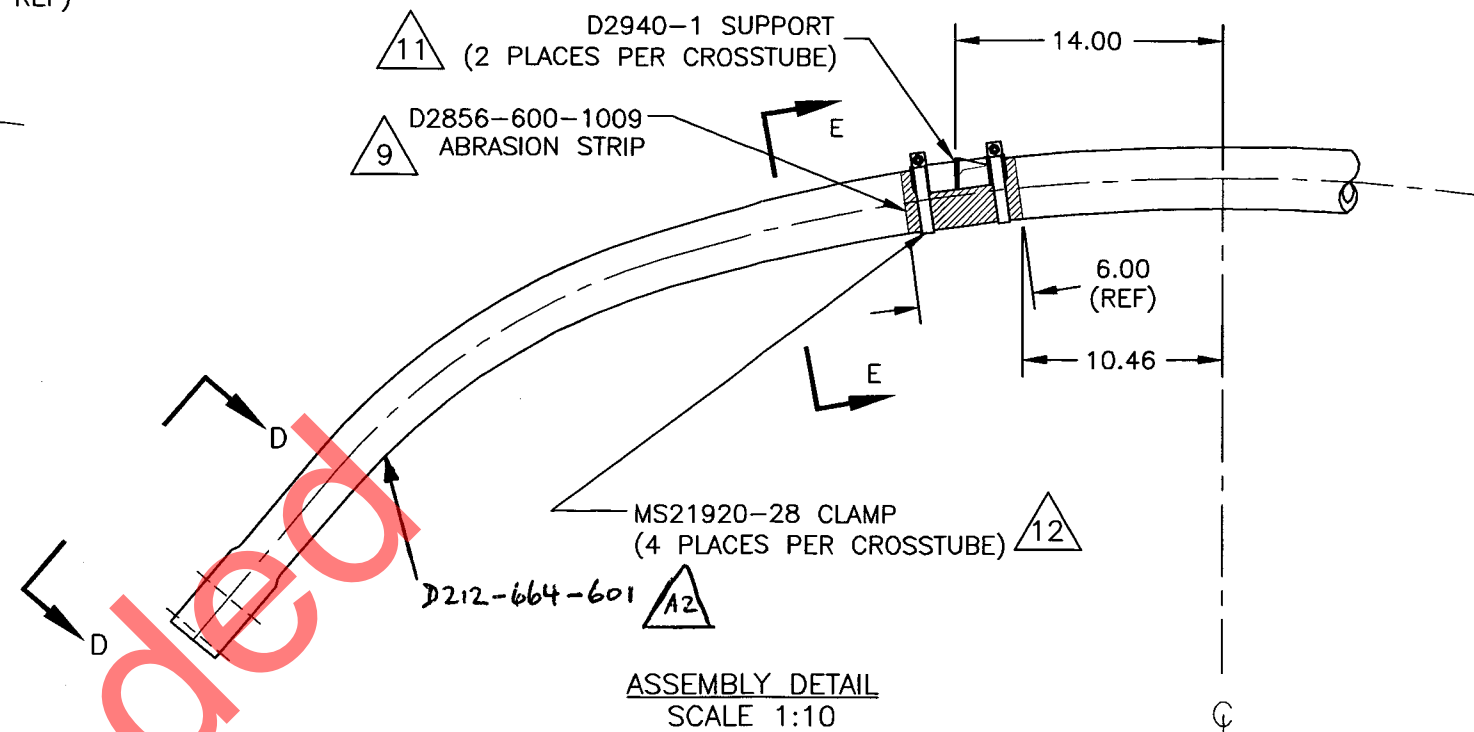
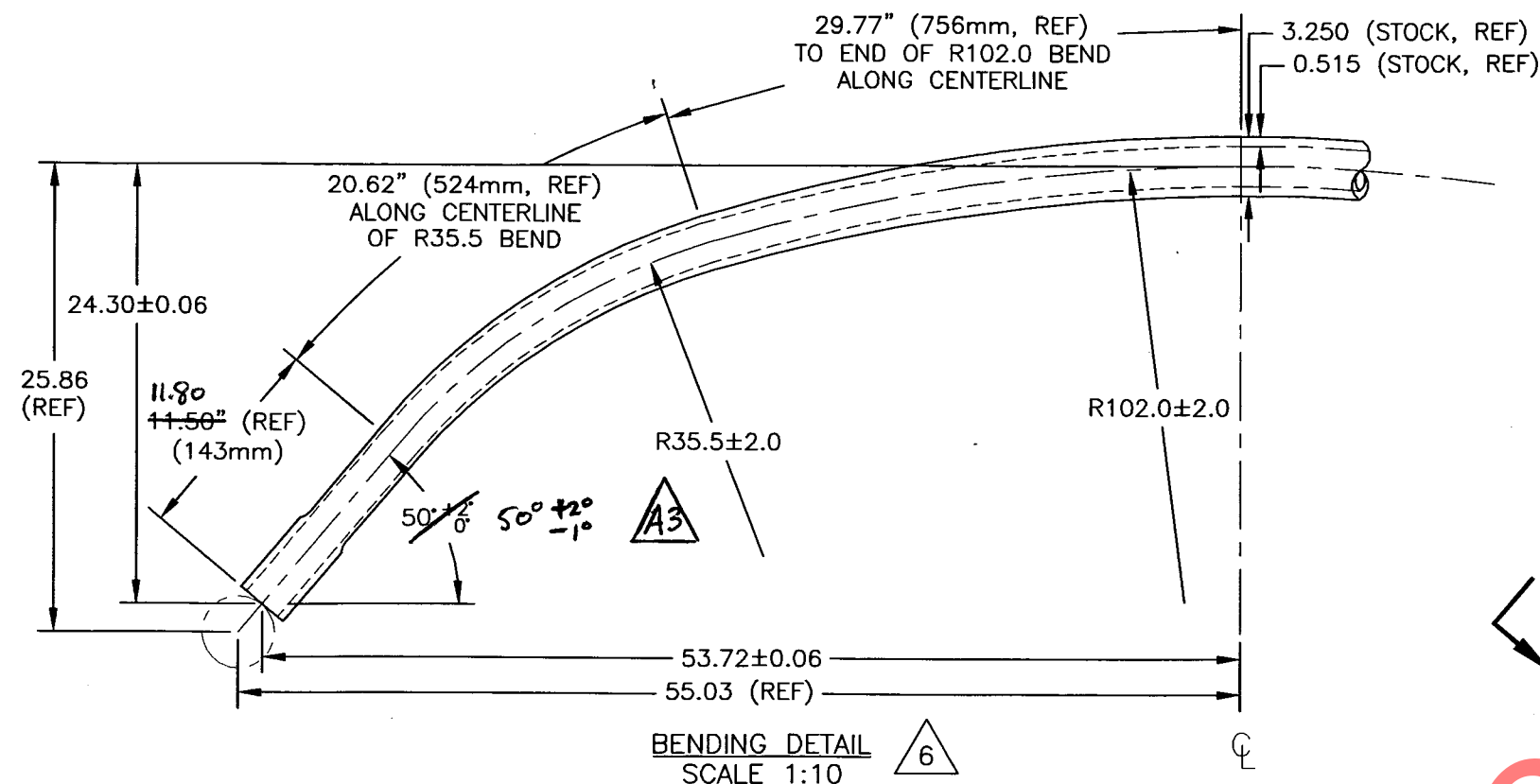
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A3	01.07.12	124.36 WAS 123.76 ; 50° ± 2° WAS 50° ± 3°
A2	01.03.07	ADD D212-664-601 P/N
A1	01.01.29	NUMBER OF PASSES WAS 8 NOW 5 DISTANCE TO BOTTOM HOLE WAS 0.390 NOW 0.450

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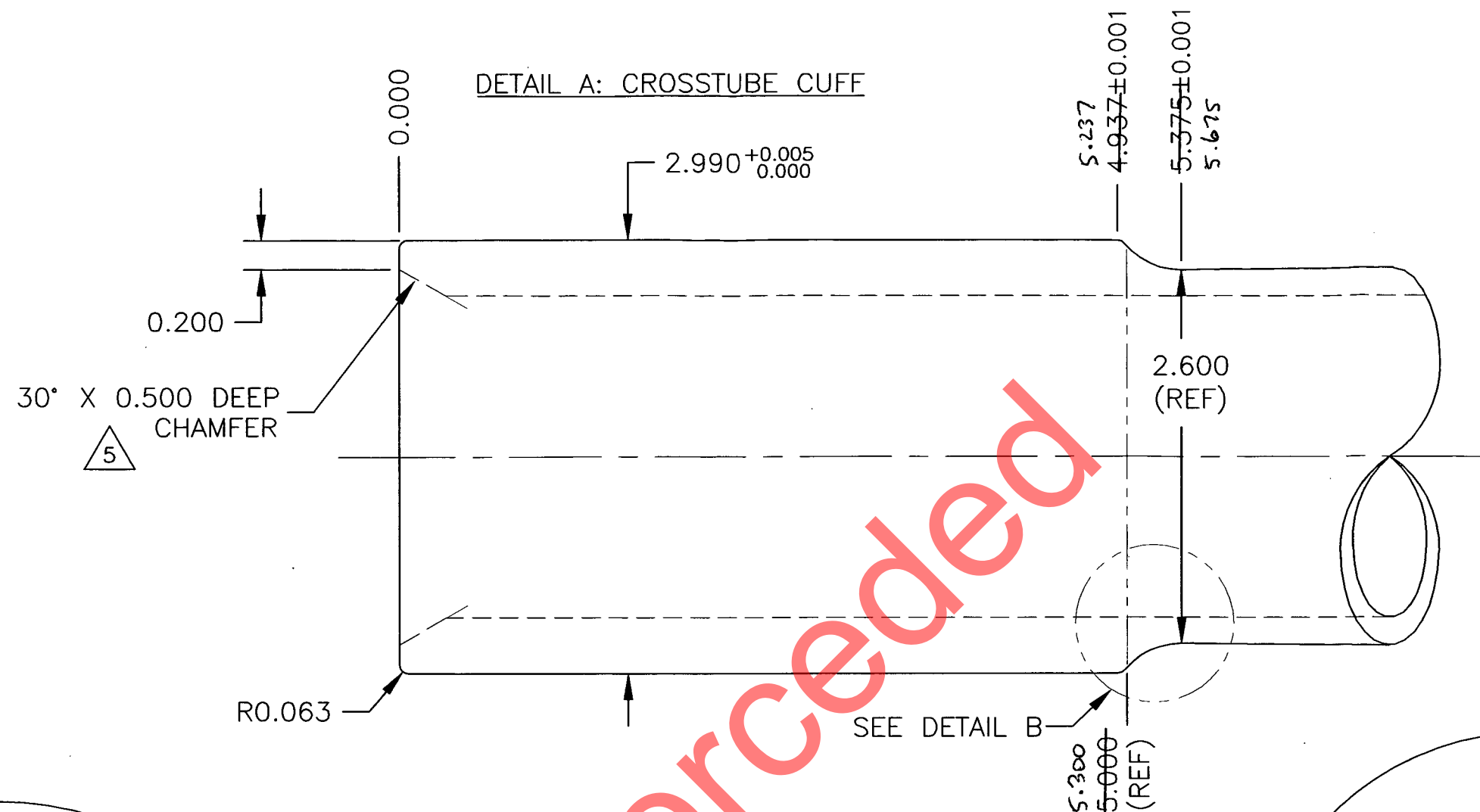
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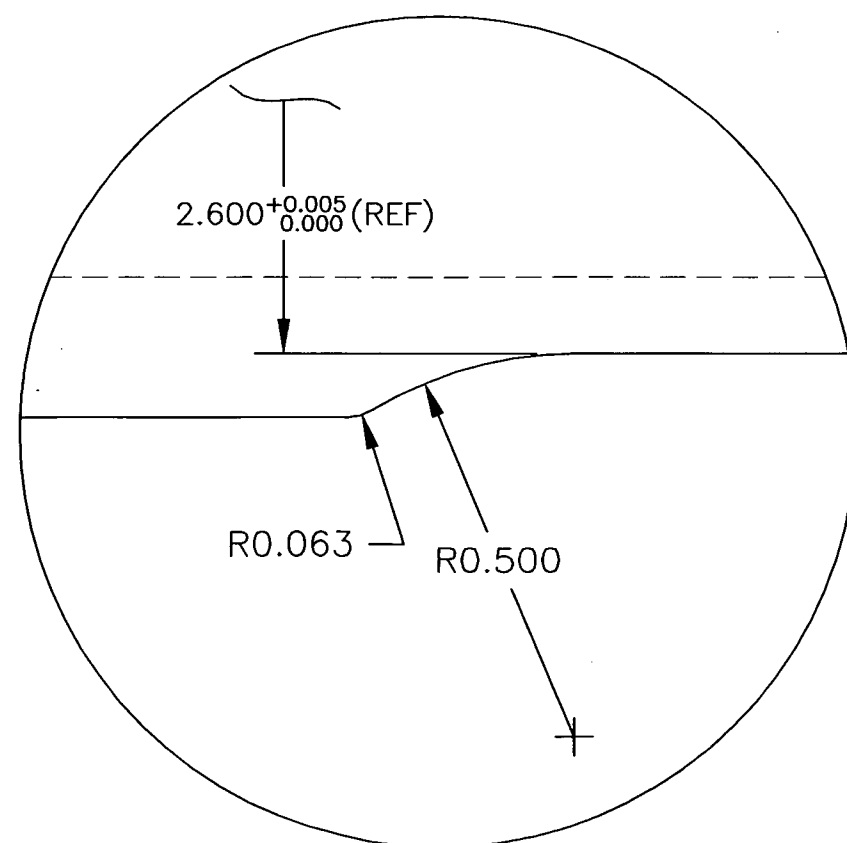
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DATE 00.12.12		TITLE CROSSTUBE ASS'Y (205/212 HI AFT)		SCALE 1:10	

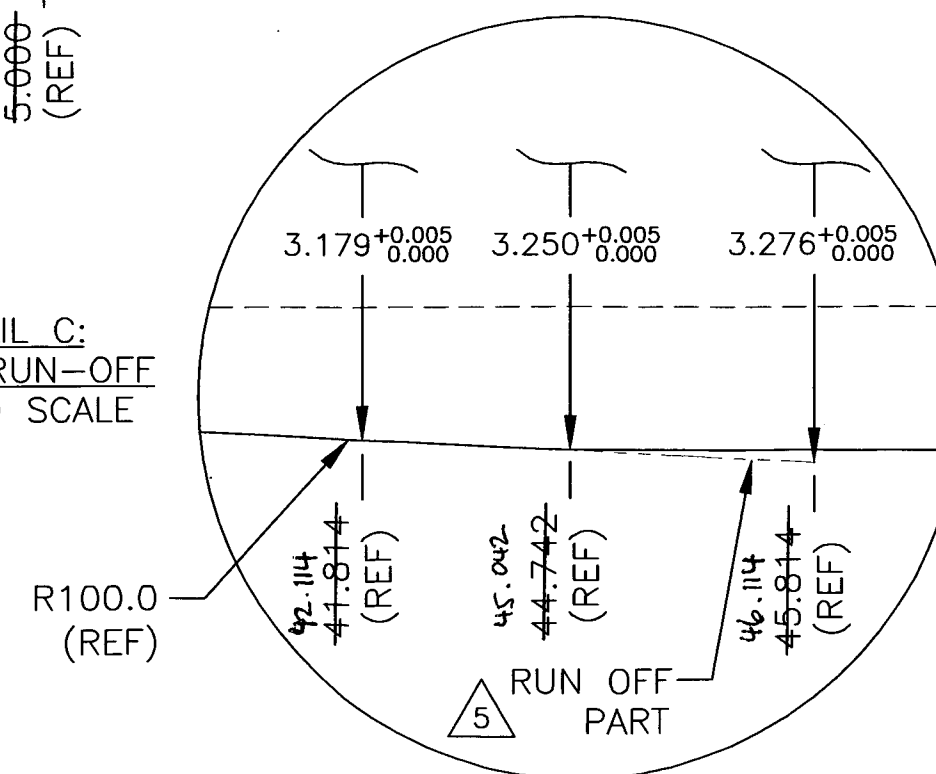
DETAIL A: CROSSTUBE CUFF



DETAIL B: CUFF
TRANSITION
SCALE 4:1



DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



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CHECKED JF	APPROVED JF	DRAWING NO. D212-664-241	REV. A SHEET 3 OF 3
DATE 00.12.12	TITLE CROSSTUBE ASS'Y (205/212 HI AFT)	SCALE 1:1	